Work Order ID 120254

120254

Wednesday, June 04, 2014 3:00:01 PM

Item ID: D4634-3 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Middle, Center Ceiling Panel

Start Date: 6/11/14 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 6/11/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-06-05 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4634 / F									
100		0.00							DAS 07 9-89
100	HAND FINISHING THERMOFORMING					YC			14/06/17
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105		0.00							DAS 07 9-89
105	Dry Material					YC			14/06/17
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F

Time IN: ~~5:00 PM~~

Time OUT: 6:00 AM

JUN 17 2014

Per.....

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Middle, Center Ceiling Panel
Start Date: 6/11/14 **Start Qty:** 1.00 *1*
Required Date: 6/11/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS 07 9-89
110	THERMOFORMING MACHINE					x1			
Thermoform	**Memo**	0.00							14/04/17
Thermoforming Machine	Thermoform as per Dwg. D4634-3 and Folio FTA145								
	Dwg. Rev. F								
	Folio Rev. E								
	NOTE: Check moulds prior to using to ensure proper placement of add-ons. Visually inspect for proper formation and texture								
130		0.00							DAS 07 9-89
130	HAND FINISHING THERMOFORMING					x1			
Thermoform	**Memo**	0.00							14/07/23
Thermoforming Machine	Trim to Finished Dimensions								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4634-3 **Accept** *N9000401100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Middle, Center Ceiling Panel

Start Date: 6/11/14 **Start Qty:** 1.00 *1*
Required Date: 6/11/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC6- Inspect dimensions to drawing	0.00							
140	Dimensional Inspection								
QC	**Memo**	0.00							
Quality Control	Fill out Inspection Sheet Rev. A								
150	QC5- Inspect part completeness to step on W/O	0.00							
150						ⓓ 14.07.29			DAS 9 9-89
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	**Memo** Section MF	0.00				ⓓ SAS 4/6/29			
Packaging									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Drill Holes
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☐ Part Lost/Missing
☐ Part Moved
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-3 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Middle, Center Ceiling Panel
Start Date: 6/11/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 6/11/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00					14/7/30		
170									
QC	**Memo**	0.00							
Quality Control									

MF 14-7-29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, June 04, 2014 2:59:59 PM

Work Order ID: 120254 *120254*

Parent Item: D4634-3 *D4634-3*

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 6/11/14 **Required Date:** 6/11/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg Update, Material Change 13/12/18 DL IPP Rev D 14/01/20 Dwg. Update DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,269.443	17.33	18			DAS 07 9-89
MLEXS.093-F6006-07									**				

GE PLASTICS LEXAN SHEET (Grey)

14/06/17

Location	Loc Qty	Loc Code	
MAT023	1269.44332		
114459	229.26		
123105	38		
124501	543.5		
m128668	181.35		
m129014	277.33332		

1294717

18 sq ft.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE.

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

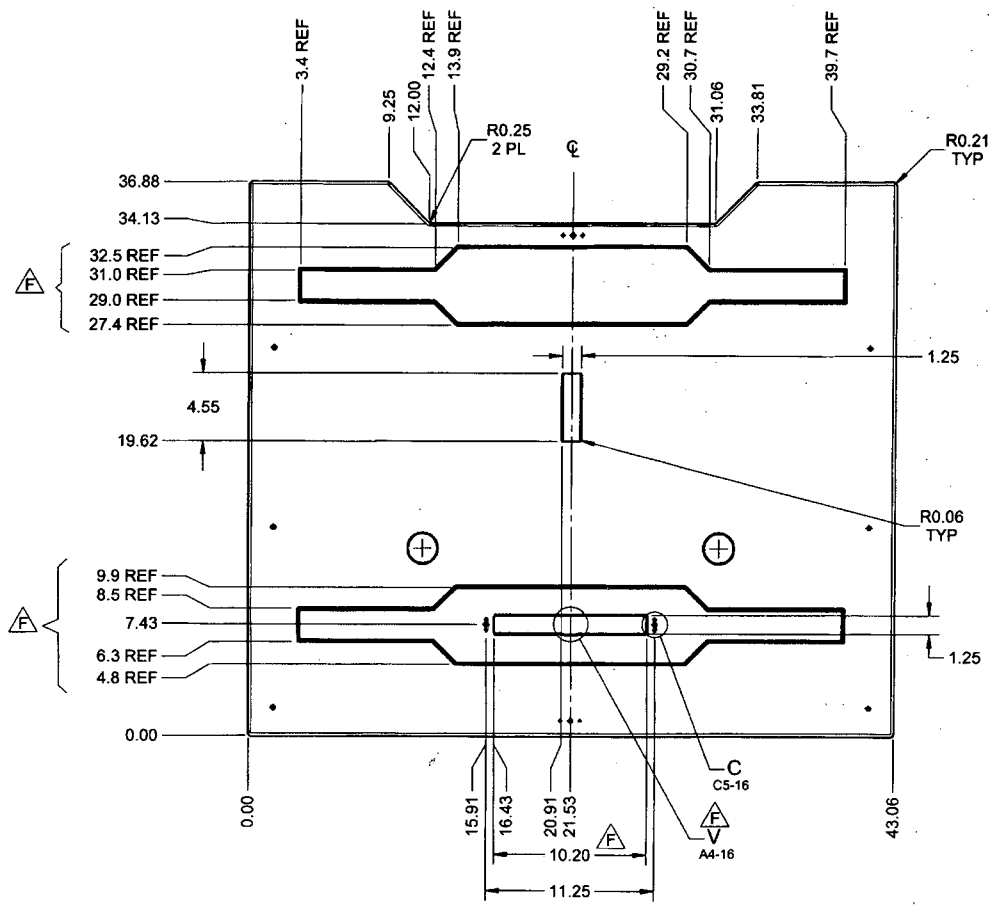
☐ Bend
☐ BOM/Route
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

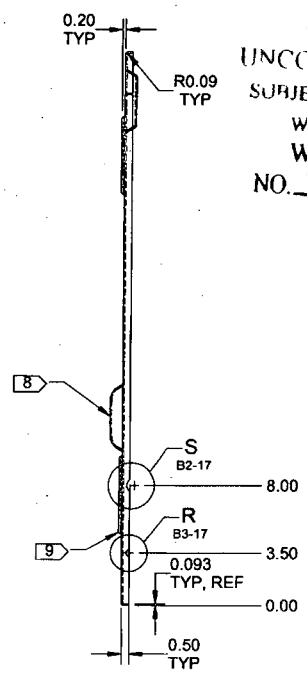
☐ Folio/Program
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120254 MCJ

14-06-05

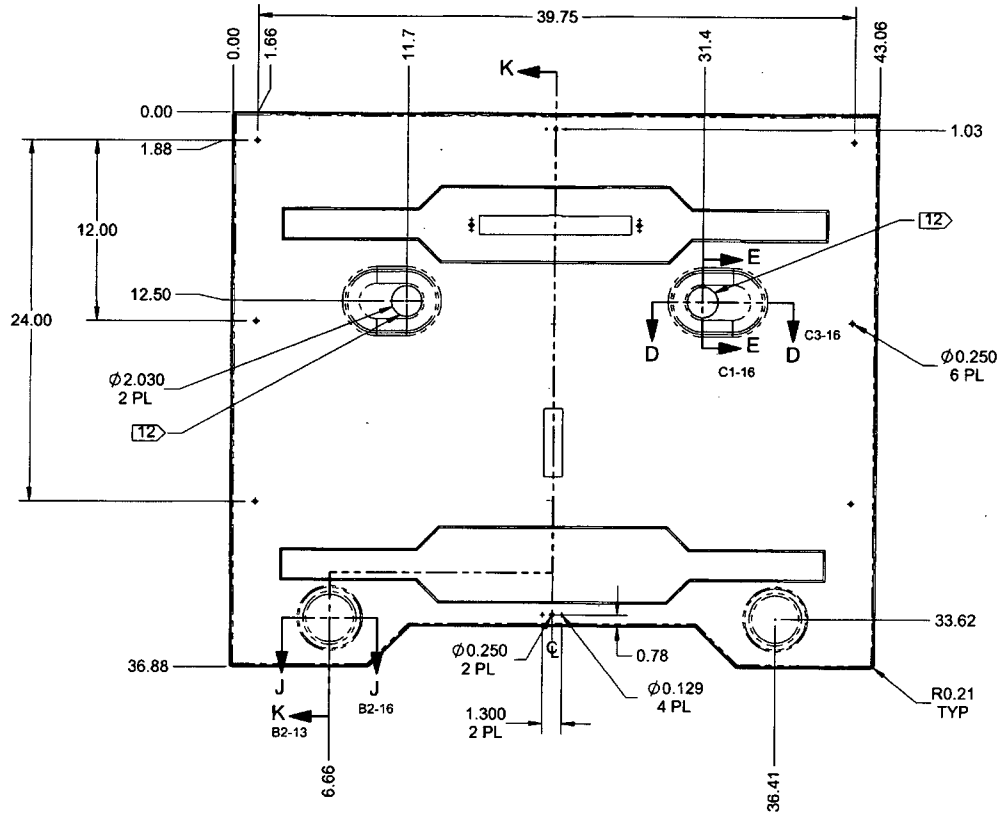
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 6.49 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-3 PER TOOL DT9837
11) THERMOFORM PER QSI 022 USING DT9845 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

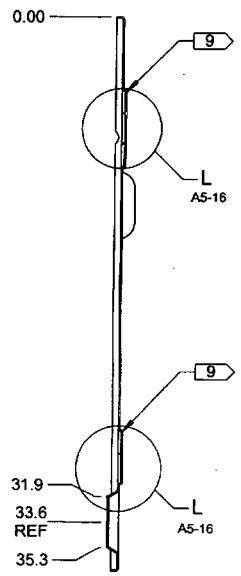
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 12 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

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D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

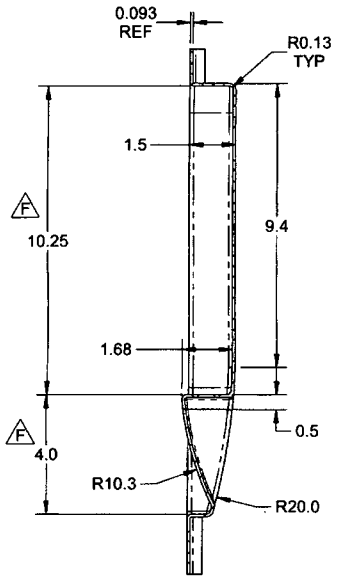


SECTION K-K B6-13

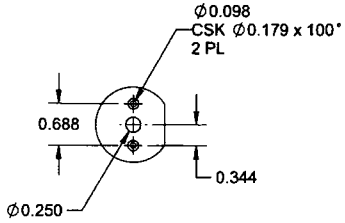
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. F
MFG. APPR.		SHEET 13 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.02.03	

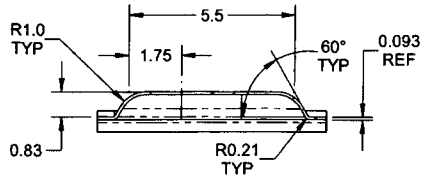
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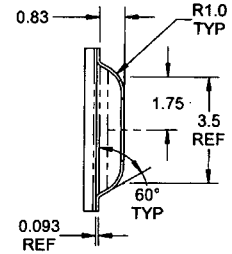
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SCALE 4X



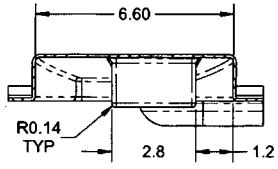
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



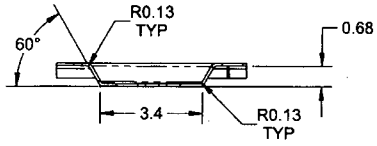
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SCALE 2X



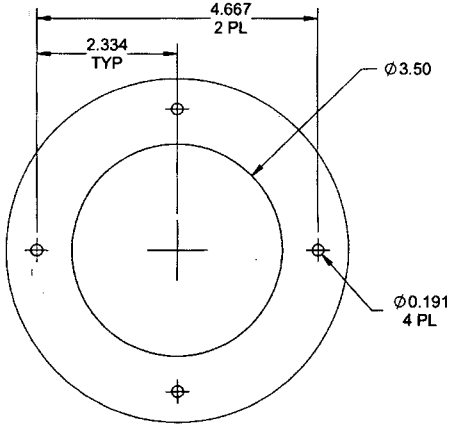
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SCALE 4X



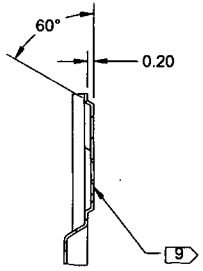
SECTION H-H C5-11
SCALE 2X



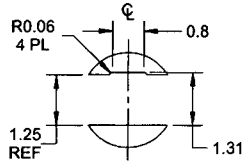
SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL



DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

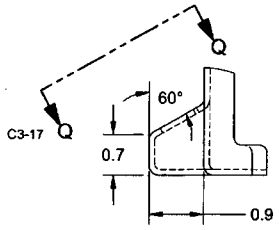


DETAIL V C4-10 B4-12 C4-14
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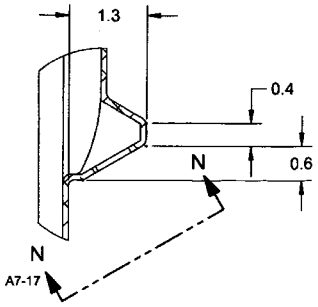
RELEASED
2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4634	REV. F
MFG. APPR.			SHEET 16 OF 17
APPROVED		TITLE CENTER CEILING PANELS	SCALE NTS
DE APPR.			
DATE 14.02.03			

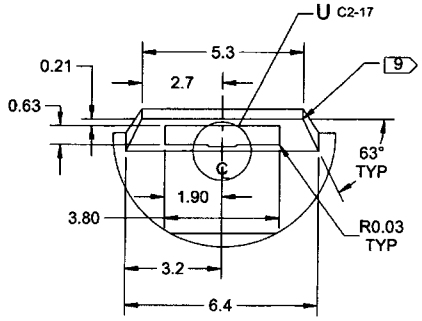
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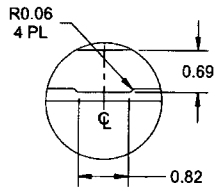
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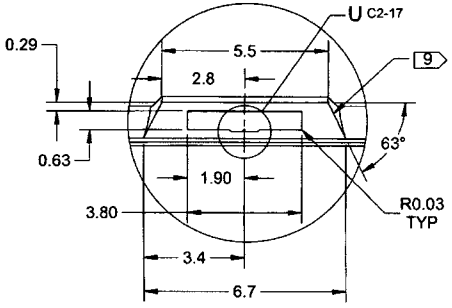
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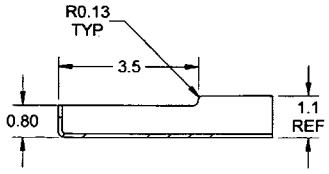
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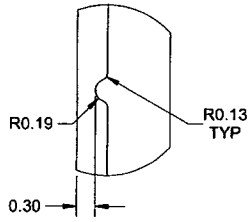
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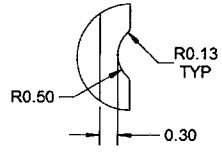
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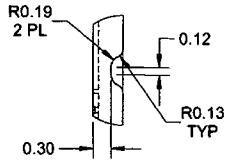
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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2014 FEB 25

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4634 REV. F
CHECKED	DC	SHEET 17 OF 17
MFG. APPR.		TITLE CENTER CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.02.03	

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DART AEROSPACE LTD

Description: Middle, center Ceiling Panel		**Work Order:**	B120254
Inspection Drawing: 4634-3	Rev: F	Part Number:	DH634-3

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.91	+/- 0.030	15.90			S. Fab - 21	
10.20	+/- 0.030	10.20			"	
11.25	+/- 0.030	11.25			"	
1.25	+/- 0.030	1.247			S. Fab - 08	
4.55	+/- 0.030	4.53			"	
1.25	+/- 0.030	1.24			"	
21.53	+/- 0.030	21.53			S Fab 21	
24.00	+/- 0.030	24.00			"	
12.00	+/- 0.030	12.00			"	
39.75	+/- 0.030	3978			"	
1.300	+/- 0.010	1.306			S. Fab - 08	
Ø 0.250	+0.005 -0.001	0.251			"	
Ø 0.129	+0.005 -0.001	0.129			"	
Ø 0.250	+0.005 -0.001	0.250			"	
Ø 2.030	+0.012 -0.001	2.031			"	
Ø 0.250	+0.005 -0.001	0.253			"	
0.688	+/- 0.010	0.693			"	
Ø 0.098	+0.004 -0.001	0.0978			"	
0.344	+/- 0.010	0.347			"	

Measured by: [signature]	**Checked By:** DAS 9 9-89	**QC inspector:** DAS 9 9-89	**Engineering Approval** (*if necessary*)**:**
Date 14/7/29	**Date** 14.07.29	**Date** 14.07.29	**Date**